

Date: Thursday, 21/08/2008 9:18:37 AM  
 User: Julie Lecocq

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 03.250 SUPPORT
Job Number	: 41536		
Estimate Number	: 10387		
P.O. Number	:	Part Number	: D29401
This Issue	: 21/08/2008 S.O. No. :	Drawing Number	: D2940 REV B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 21/08/2008 Type : MACHINED PARTS	Drawing Revision	: B
Previous Run	: 40753	Material	:
Written By	:	Due Date	: 28/08/2008 Qty: 20 Um: Each
Checked & Approved By	: <u>JUL 08.8.21</u>		
Comment	: Est. C 02.11.26 Reformat; Added P/O KJ Est Rev:D Added priming as per Rev B 07-04-30 JLM est E 08.03.19 Re-format Ec verified by DD		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DSK081	D2940-1 TURNING DETAIL
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Comment: Qty.: 0.5000 Each(s)/Unit Total: 10.0000 Each(s)  
 D2940-1 TURNING DETAIL  
 Batch: 41529 JIP 08/10/02

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS  
 1- Machine as per Folio FA079  
 2- Tumble & Deburr

JIP 08/10/03

S.P 08/10/05

3.0	QC1	INSPECT ALL DIM TO DIM SHEET
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Comment: INSPECT ALL DIM TO DIM SHEET

JIP 08/10/03

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

10 08/10/09

5.0	POWDER COATING	POWDER COATING
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M109152



(20X)

Comment: POWDER COATING  
 Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3  
 \*\*\*\*\*Mask Inside Surface as per Dwg D2940\*\*\*\*\*

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

3:40  
01:00  
4:10

M. 08/10/14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Thursday, 21/08/2008 9:18:37 AM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 03.250 SUPPORT

Job Number: 41536

Part Number: D29401

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

SPRAY PAINTING

SPRAY PAINTING



Comment: SPRAY PAINTING

Prime inside surface as per Dwg D2940 and QSI 005 4.3.

RT 0610-21 (20)

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

0610-22 (20)

P70

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: X tube assy

RT 0810-22 (20)

9.0

QC21

FINAL INSPECTION/W/O RELEASE




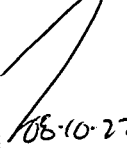
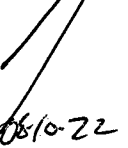
Comment: FINAL INSPECTION/W/O RELEASE

0810/22 (20)

Job Completion



U 0810.22

W/O: 41536		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
08-10-22	7.0	QC 14 required. Perm. Change.  ESTIMATE # 10387		08/10/22		 08-10-22	 08-10-22

Part No: D2940-1 PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<del>08-10-22</del>	<del>7.0</del>							

NOTE: Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 41536
<b>Description:</b> Ø3.250 Support		<b>Part Number:</b> D2940-1
<b>Inspection Dwg:</b> D2940	<b>Rev:</b> B	<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
HAAS Section								
AA	0.240	0.260		0.250	0.250	.250	.250	.250
AB	0.490	0.510		0.500	0.500	.500	.500	.500
AC	0.140	0.160		0.150	0.150	.151	.154	.152
AD	3.510	3.530		3.517	3.518	3.520	3.520	3.520
AE	1.633	1.673		1.656	1.655	1.655	1.654	1.654
AF	1.493	1.513		1.503	1.506	1.506	1.500	1.500
AG	0.040	0.060		0.055	0.055	.050	.050	.050
AH	0.188	0.193		0.189	0.189	.188	.188	.188
AI	0.140	0.160		0.156	0.150	.156	.154	.154
AJ	2.518	2.538		2.530	2.530	2.525	2.530	2.530
AK	0.040	0.060		0.050	0.050	.047	.051	.051
AL	0.010	0.020		0.015	0.015	.015	.015	.015
AM	0.140	0.160		0.145	0.145	.153	.154	.155
AN	0.350	0.450		0.375	0.375	.405	.405	.408
AO	0.240	0.260		0.250	0.015	.250	.250	.250
AP	0.150	0.170		0.153	0.150	.151	.151	.151
AQ	0.053	0.073		0.055	0.055	.063	.063	.063
AR	101.64	105.64		103.64	103.64	103.64	103.64	103.64
AS	0.260	0.267		0.263	0.263	.262	.262	.262
AT	0.053	0.073		0.063	0.063	.063	.063	.063
AU	4.118	4.138		4.135	4.135	4.135	4.135	4.130
AV								
AW								
Accept/Reject								

Measured by: DAP / LF

Date: 08/10/03 / 08/01/05

Audited by: EC

Date: 08/10/09

Prototype Approval:

Date:

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	07.05.08	Dwg Rev. updated	KJ/JLM	
C	07.07.18	Dimension AS revised	KJ/JLM	
D	08.04.22	Reformat	KJ/JLM	

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 41536
<b>Description:</b> Ø3.250 Support		<b>Part Number:</b> D2940-1
<b>Inspection Dwg:</b> D2940	<b>Rev:</b> B	<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	6X	72	92	94	105
HAAS Section								
AA	0.240	0.260		.250	.250	.250	.250	0.250
AB	0.490	0.510		.500	.500	.500	.500	0.500
AC	0.140	0.160		.149	.149	.149	.149	0.150
AD	3.510	3.530		3.520	3.520	3.520	3.520	3.520
AE	1.633	1.673		1.654	1.655	1.655	1.655	1.660
AF	1.493	1.513		1.500	1.500	1.500	1.500	1.506
AG	0.040	0.060		.050	.050	.050	.050	0.050
AH	0.188	0.193		.188	.188	.188	.188	0.190
AI	0.140	0.160		.150	.150	.150	.150	0.155
AJ	2.518	2.538		2.530	2.530	2.530	2.530	2.530
AK	0.040	0.060		.050	.050	.050	.050	0.050
AL	0.010	0.020		.015	.015	.015	.015	0.015
AM	0.140	0.160		.150	.150	.150	.150	0.150
AN	0.350	0.450		.400	.400	.400	.400	0.375
AO	0.240	0.260		.250	.250	.250	.250	0.250
AP	0.150	0.170		.165	.165	.165	.165	0.155
AQ	0.053	0.073		.063	.063	.063	.063	0.055
AR	101.64	105.64		103.64	103.64	103.64	103.64	103.64
AS	0.260	0.267		.262	.262	.262	.262	0.263
AT	0.053	0.073		.063	.063	.063	.063	0.063
AU	4.118	4.138		4.130	4.130	4.130	4.130	4.130
AV								
AW								
Accept/Reject								

<b>Measured by:</b> <i>ST</i>	<b>Date:</b> 08/10/06
<b>Audited by:</b> <i>29</i>	<b>Date:</b> 08/10/09
<b>Prototype Approval:</b>	<b>Date:</b>

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	07.05.08	Dwg Rev. updated	KJ/JLM	
C	07.07.18	Dimension AS revised	KJ/JLM	
D	08.04.22	Reformat	KJ/JLM	<i>[Signature]</i>

DART AEROSPACE LTD		Work Order: 41530
Description: Ø3.250 Support		Part Number: D2940-1
Inspection Dwg: D2940	Rev: B	Page 1 of 1

### FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	11	12	13	14	15
HAAS Section								
AA	0.240	0.260		0.250	0.250	0.250	0.250	0.250
AB	0.490	0.510		0.500	0.500	0.500	0.500	0.250
AC	0.140	0.160		0.150	0.150	0.154	0.155	0.155
AD	3.510	3.530		3.520	3.520	3.520	3.515	3.515
AE	1.633	1.673		1.656	1.656	1.656	1.657	1.653
AF	1.493	1.513		1.506	1.505	1.506	1.506	1.506
AG	0.040	0.060		0.050	0.050	0.050	0.050	0.050
AH	0.188	0.193		0.190	0.190	0.190	0.190	0.190
AI	0.140	0.160		0.150	0.150	0.153	0.155	0.153
AJ	2.518	2.538		2.530	2.530	2.530	2.530	2.530
AK	0.040	0.060		0.050	0.050	0.050	0.050	0.050
AL	0.010	0.020		0.015	0.015	0.015	0.015	0.015
AM	0.140	0.160		0.150	0.150	0.148	0.148	0.148
AN	0.350	0.450		0.375	0.375	0.375	0.375	0.375
AO	0.240	0.260		0.250	0.250	0.250	0.250	0.250
AP	0.150	0.170		0.150	0.150	0.150	0.150	0.150
AQ	0.053	0.073		0.055	0.055	0.055	0.055	0.055
AR	101.64	105.64		103.64	103.64	103.64	103.64	103.64
AS	0.260	0.267		0.263	0.263	0.263	0.263	0.263
AT	0.053	0.073		0.063	0.063	0.063	0.063	0.063
AU	4.118	4.138						
AV								
AW								
Accept/Reject								

Measured by: DSP	Date: 08/10/07
Audited by: [Signature]	Date: 08/10/07
Prototype Approval:	Date:

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	07.05.08	Dwg Rev. updated	KJ/JLM	
C	07.07.18	Dimension AS revised	KJ/JLM	
D	08.04.22	Reformat	KJ/JLM	[Signature]

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 41534
<b>Description:</b> Ø3.250 Support		<b>Part Number:</b> D2940-1
<b>Inspection Dwg:</b> D2940	<b>Rev:</b> B	<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

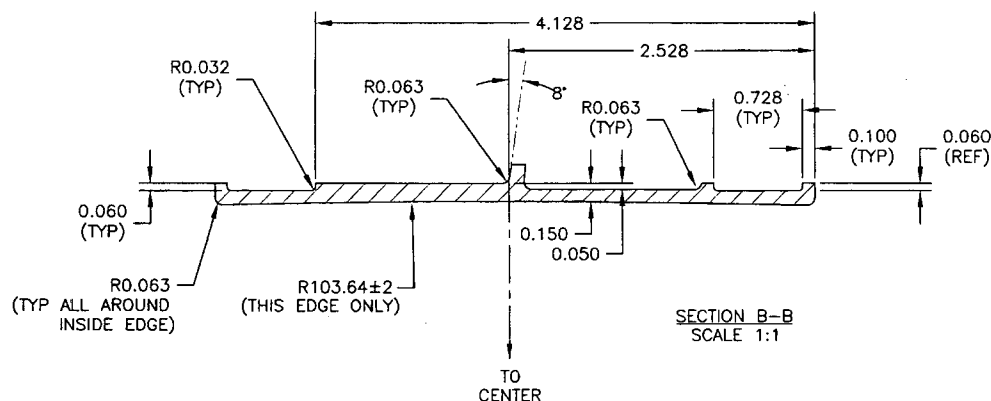
				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	16	17	18	19	20
HAAS Section								
AA	0.240	0.260		0.250	0.250	0.250	0.250	0.250
AB	0.490	0.510		0.500	0.500	0.500	0.500	0.500
AC	0.140	0.160		0.150	0.153	0.153	0.153	0.152
AD	3.510	3.530		3.514	3.526	3.523	3.523	3.523
AE	1.633	1.673		1.655	1.658	1.659	1.655	1.6585
AF	1.493	1.513		1.501	1.500	1.505	1.500	1.505
AG	0.040	0.060		0.050	0.048	0.049	0.048	0.050
AH	0.188	0.193		0.190	0.190	0.190	0.190	0.190
AI	0.140	0.160		0.151	0.156	0.155	0.156	0.153
AJ	2.518	2.538		2.530	2.530	2.530	2.530	2.528
AK	0.040	0.060		0.050	0.050	0.050	0.050	0.050
AL	0.010	0.020		0.015	0.015	0.015	0.015	0.015
AM	0.140	0.160		0.148	0.147	0.145	0.146	0.145
AN	0.350	0.450		0.380	0.380	0.380	0.380	0.380
AO	0.240	0.260		0.250	0.250	0.250	0.250	0.250
AP	0.150	0.170		0.150	0.158	0.154	0.155	0.15035
AQ	0.053	0.073		0.055	0.055	0.055	0.055	0.055
AR	101.64	105.64		103.64	103.64	103.64	103.64	103.64
AS	0.260	0.267		0.263	0.263	0.263	0.263	0.263
AT	0.053	0.073		0.063	0.063	0.063	0.063	0.063
AU	4.118	4.138						
AV								
AW								
Accept/Reject								

<b>Measured by:</b> DTP	<b>Date:</b> 08/10/07
<b>Audited by:</b> RP	<b>Date:</b> 08/10/07
<b>Prototype Approval:</b>	<b>Date:</b>

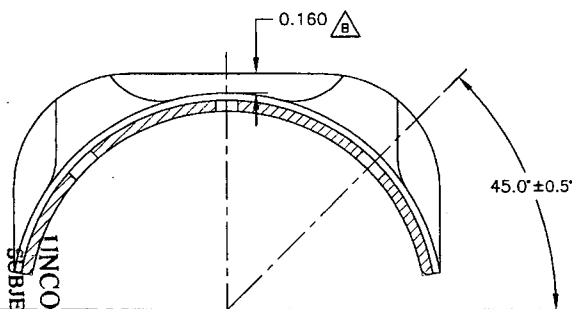
Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	07.05.08	Dwg Rev. updated	KJ/JLM	
C	07.07.18	Dimension AS revised	KJ/JLM	
D	08.04.22	Reformat	KJ/JLM	



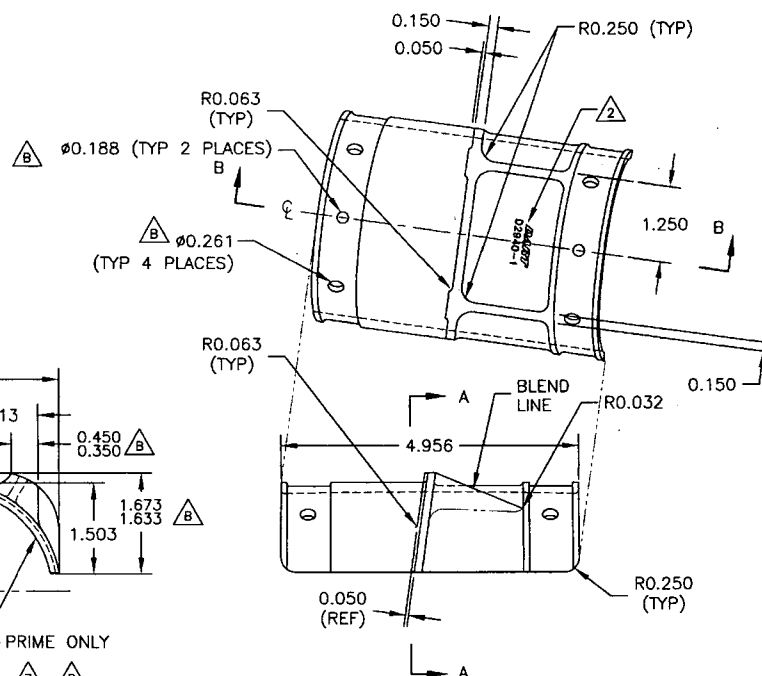
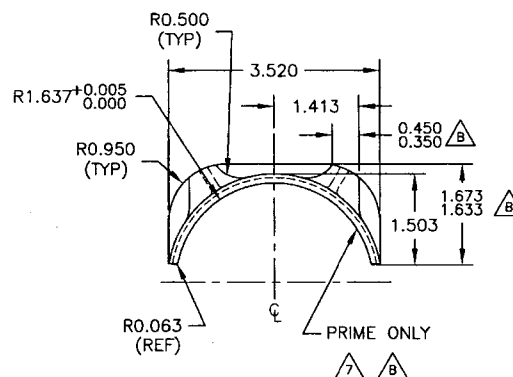
RELEASED  
67.04.24  
PER ECN 857



SECTION B-B  
SCALE 1:1



SECTION A-A  
COOLING HOLE DETAIL  
SCALE 1:1



NO. 41530  
WORK ORDER  
WITHOUT NOTICE  
SUBJECT TO AMENDMENT  
UNCONTROLLED COPY  
RETURN TO  
ENGINEERING  
SHOP COPY

- 1) MATERIAL: 7-4 PH STAINLESS STEEL  
HEAT TREAT TO H900 CONDITION  
(900°F FOR 1 HR, AIR COOL)  
MIN UTS = 170 KSI (38 HRc)
- 2) IDENTIFY WITH DART LOGO AND PART NUMBER IN THIS AREA  
WITH 0.125 HIGH LETTERING 0.010-0.020 DEEP
- 3) BREAK ALL UNMARKED SHARP EDGES 0.010 TO 0.020
- 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) FINISH: POWDER COAT WHITE (REF 4.3.5.2) PER DART QSI 005 4.3  
PRIME INSIDE SURFACE AS SHOWN PER DART QSI 005 4.2

B	07.03.16	UPDATE PER NCR 642, PRIME INSIDE
A	01.01.10	NEW ISSUE
DESIGN	97	DRAWN BY 94
CHECKED	97	APPROVED 94
DATE	07.03.16	TITLE Ø3.250 SUPPORT
DART AEROSPACE LTD.		REV. B
DART AEROSPACE LTD.		SHEET 1 OF 1
DART AEROSPACE LTD.		SCALE 1:2

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